

2

Work Order ID 83094

April-12-12 4:13:26 PM

\*83094\*

Page 1

Item ID: D212-664-201TRN

Accept

Revision ID:

Item Name: Crosstube Turning Detail

Start Date: 12/04/2012 Start Qty: 1.00

\*1\*

Required Date: 26/04/2012 Req'd Qty: 1.00

\*1\*

Reference:

Approvals: Process Plan: ML5

Date: 12/04/13 Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set-Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D212-664-241	Rev D
--------------	-------

100

\*100\*

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Mori Seiki CNC Lathe Large

Memo

0.00

1 0

MAN.L  
12/05/02

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA114

2-Turn first side as per Folio FA114

3-Blend transition lines only, \*\*do not sand whole tube\*\*

FOLIO REV: AD

DWG REV: D

\*Use mill bastard file, brush file repeatedly with file card.

\*Do not use sandpaper coarser than 320 grit.

110

QC1- Inspect dimensions to dimension sheet

0.00

1 0

\*110\*

QC

Quality Control

Memo

0.00

MAN.L  
12/09/02

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 83094**

April-12-12 4:13:26 PM

**\*83094\***

Page 2

Item ID: D212-664-201TRN

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Crosstube Turning Detail

Start Date: 12/04/2012 Start Qty: 1.00 **\*1\***Required Date: 26/04/2012 Req'd Qty: 1.00 **\*1\***

Cust Item ID:

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	<b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:		Stop	<b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> Mori Seiki	MORI SEIKI CNC LATHE LARGE  Memo 1-Turn second side as per Folio FA114  2-Blend transition lines only, **do not sand whole tube**: *Use mill bastard file, brush file repeatedly with file card. *Do not use sandpaper coarser than 320 grit. FOLIO REV: <u>A</u> DWG REV: <u>D</u> 3-Remove sand and plugs  4- scribe batch # and part # as per dwg	0.00				1	0	KC	12-05-12
130 <b>*130*</b> QC Quality Control	QC1- Inspect dimensions to dimension sheet  Memo	0.00				1	0	KC	12-05-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 83094

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Page 3

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Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Crosstube Turning Detail

Start Date: 12/04/2012 Start Qty: 1.00

\*1\*

Required Date: 26/04/2012 Req'd Qty: 1.00

\*1\*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

\*140\*

QC

Quality Control

QC8- Inspect parts - second check

0.00

DAS  
03  
12-5-14

JW

12-5-14

145

\*145\*

Crosstubes

Crosstubes

Memo

0.00

Memo

0.00

GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.

JW

12-5-22

150

\*150\*

HandFXtube

Hand Finishing Crosstubes

Crosstubes Chemical Conversion

0.00

Memo

(Acid Etch only)

0.00

JW  
12-5-17

JW

12-5-22

W/O:		WORK ORDER CHANGES							
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Page 4

Item ID: D212-664-201TRN

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\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Crosstube Turning Detail

Stop

\*NS2\*

Start Date: 12/04/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Memo	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 <b>*160*</b> QC Quality Control	QC1-Inspect Chemical Conversion Coat		0.00		D45 03 89					DP 12-7-23
170 <b>*170*</b> Packaging Packaging	Packaging	Memo	0.00		NO					12-7-23
		Identify and stock in kanban rack Location: 16								
180 <b>*180*</b> QC Quality Control	QC21-Final Inspection - Work Order Release	Memo	0.00							12/1/23 J

MF  
12-07-23

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	83094
Description: Crosstube Assembly (205/212 High Aft)	Part Number:	D212-664-241
Inspection Dwg: D212-664-241 Rev: D		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	200	/	VERN	CNC - 08
	R0.063	+/-0.010	.063	/	R6	
	2.990	+0.005/-0.000	2.992	/	MIC	CNC - 04
	5.237	+/-0.030	5.237	/		
	2.600	+0.005/-0.000	2.604	/		
	2.686	+0.005/-0.000	2.690	/		
	2.770	+0.005/-0.000	2.773	/		
	2.854	+0.005/-0.000	2.857	/		
	2.938	+0.005/-0.000	2.940	/		
	3.021	+0.005/-0.000	3.023	/		
	3.133	+0.005/-0.000	3.136	/		
	3.179	+0.005/-0.000	3.182	/		
SIDE B	0.200	+/-0.010	200	/	VERN	CNC - 08
	R0.063	+/-0.010	.063	/	R6	
	2.990	+0.005/-0.000	2.992	/	MIC	CNC - 04
	5.237	+/-0.030	5.237	/		
	2.600	+0.005/-0.000	2.601	/		
	2.686	+0.005/-0.000	2.683	/		
	2.770	+0.005/-0.000	2.773	/		
	2.854	+0.005/-0.000	2.858	/		
	2.938	+0.005/-0.000	2.943	/		
	3.021	+0.005/-0.000	3.023	/		
	3.133	+0.005/-0.000	3.136	/		
	3.179	+0.005/-0.000	3.183	/		
	124.362	+/-0.020	124.362	-	Tape	vern - 02

ED-11

Measured by:	<i>M.M.L/KC.</i>	Audited by:	<i>[Signature]</i>	Preliminary Approval:	N/A
Date:	<i>12/05/02</i>	Date:	<i>12-5-14</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-201)	KJ/JLM	
B	06.03.09	Tolerance for 5.237 was +/-0.001	KJ/JLM	
C	07.05.08	Dwg Rev. updated	KJ/JLM	
D	10.08.03	Dimension 124.362 was 124.36	KJ <i>[Signature]</i>	<i>M</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

D

Item	Qty -241	Qty -241B	Part Number	Description
1	X		D212-664-241	CROSSTUBE ASSEMBLY (205/212 HIGH AFT)
2		X	D212-664-241B	CROSSTUBE ASSEMBLY (214 HIGH AFT)
3	1	1	D6006-129	CROSSTUBE
4	2	2	D2940-1	SUPPORT
5	4	4	D3595-063-530	RUBBER CUSHION
6	4	4	MS21920-28	CLAMP (OR MS21920-30)
7	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6006-129  
FINISHED LENGTH = 124.362±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF  
USING VIBRATING STYLUS
- 7) WEIGHT: D212-664-241 = 44.2 lbs (PER IIN-D212-664)  
D212-664-241B = 44.2 lbs (PER IIN-D212-664)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING  
IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE  
OF D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS  
AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE THE D2940-1  
SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE  
SUPPORT.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE  
SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR  
DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND  
MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT  
HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 83094 ML5

600 H11-614

11.08.28

12/04/13

UNDER REVIEW

07/06/13

DEO ATTACHED

RELEASED

2009-10-29

D	REFORMAT/REVISE GENERAL NOTES/PART LIST; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -241B (ZN D4-2, B4-2); REMOVED REF & ADD TOLERANCES (ZN D8-3 & C4-3, C6-3 & A8-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE -1009 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	PH	00.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PP	DRAWING NO.	REV. D
MFG. APPR.	DS	D212-664-241	SHEET 1 OF 4
APPROVED	MM	TITLE	SCALE
DE APPR.	MM	CROSSTUBE ASSY (205/212 HI AFT)	NTS
DATE	09.09.30	COPRIGHT © 2000 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE OR SHOWN TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

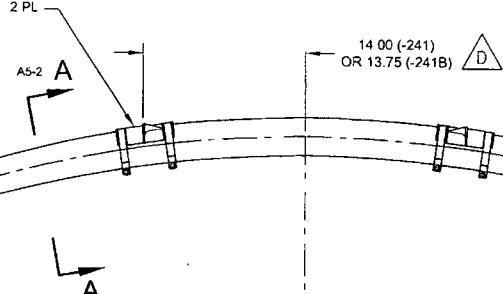
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

8 7 6 5 4 3 2 1

12 13 15  
D2940-1 SUPPORT  
MS21920-28 CLAMP, 2X  
D3595-063-530 RUBBER CUSHION, 2X  
2 PL

03094



D212-664-601  
BENT TUBE

SYM

D212-664-241/-241B  
ASSEMBLY DETAIL

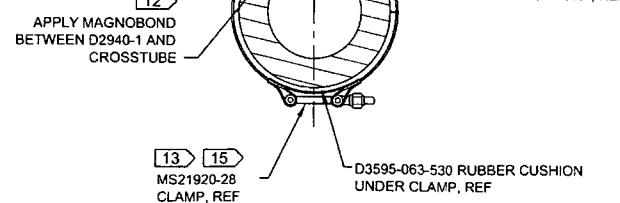
UNDER REVIEW

07/06/13

600#(L-614  
11.07.26

DEO ATTACHED

RELEASED  
2009-10-28  
JW



APPLY MAGNOMBOND  
BETWEEN D2940-1 AND  
CROSSTUBE  
12  
13 15  
MS21920-28  
CLAMP, REF  
D2940-1 SUPPORT, REF  
D3595-063-530 RUBBER CUSHION  
UNDER CLAMP, REF

SECTION A-A D6-2  
SCALE 4X

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	PP	DRAWING NO.
MFG. APPR.	DS	REV. D
APPROVED	ND	D212-664-241
DE APPR.	ND	SHEET 2 OF 4
DATE	09.09.30	SCALE
TITLE		
CROSSTUBE ASSY (205/212 HI AFT) NTS		
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8 7 6 5 4 3 2 1

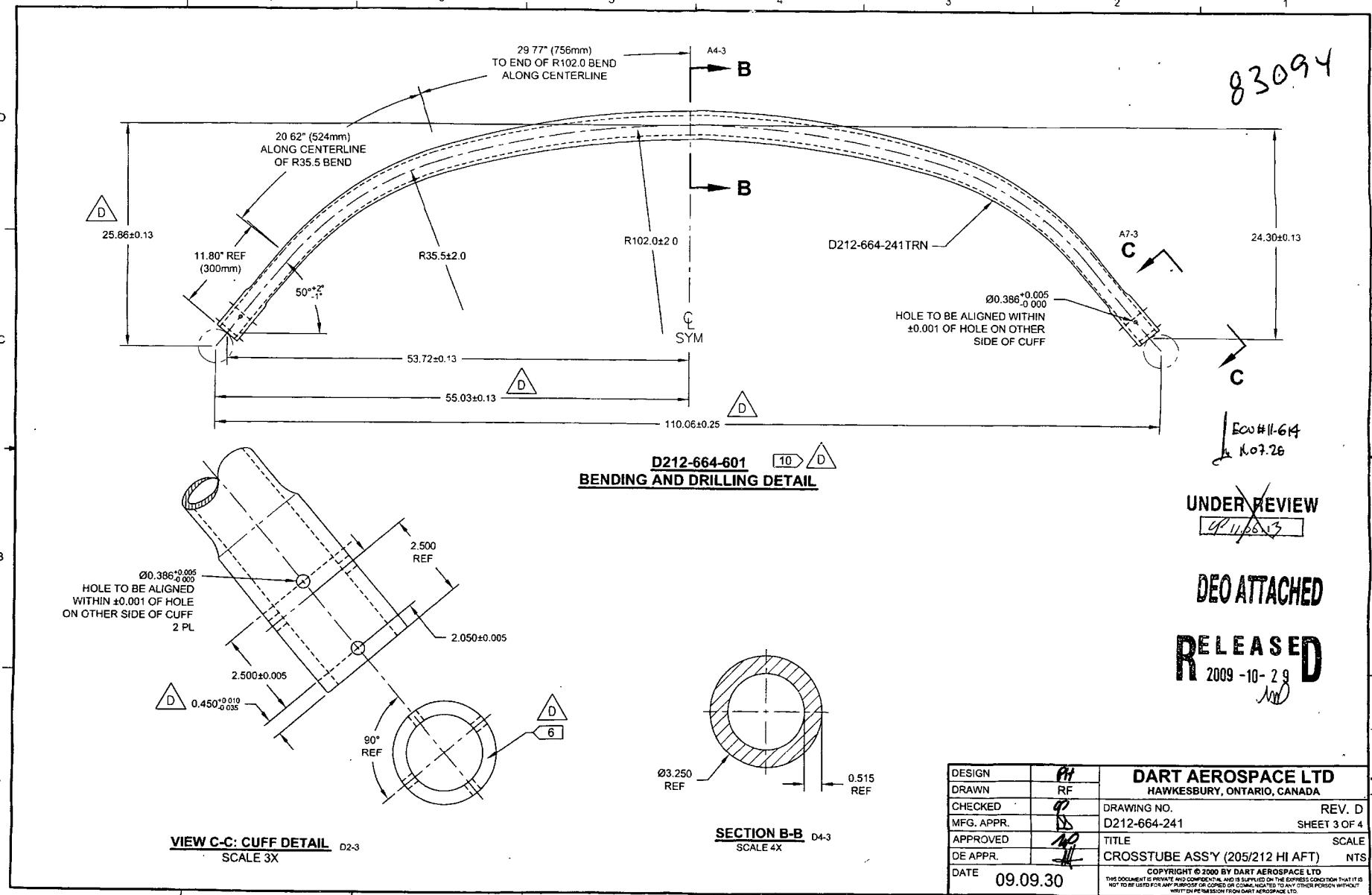
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DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	PP	DRAWING NO. REV. D
MFG. APPR.	DS	D212-664-241 SHEET 3 OF 4
APPROVED	MM	TITLE
DE APPR.	MM	SCALE
DATE	09.09.30	CROSSTUBE ASS'Y (205/212 HI AFT) NTS

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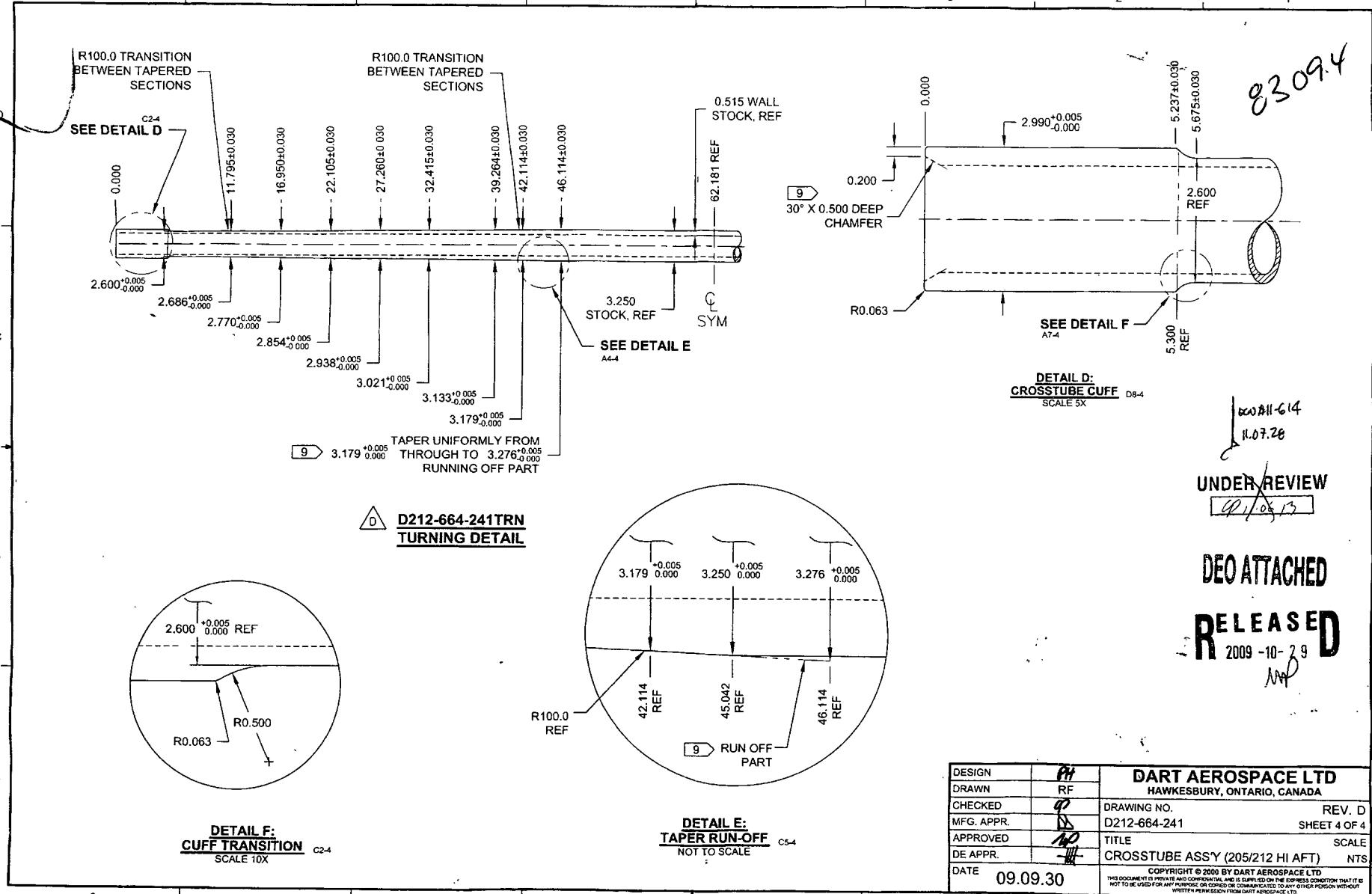
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CHECKED	QD	DRAWING NO.
MFG. APPR.	DA	REV. D
APPROVED	AD	SHEET 4 OF 4
DE APPR.	ML	TITLE
DATE	09.09.30	CROSSTUBE ASS'Y (205/212 HI AFT) NTS

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DRAWING NO. D212-664-241	TITLE CROSSTUBE ASSY (205/212 HI AFT)	REV. D	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D212-664-241-D-1	SHEET NO. SHEET 1 OF 2	SCALE NTS
DRAWN <i>W</i>	CHECKED <i>W</i>	MFG. APPR. <i>E</i>	APPROVED <i>W</i>	DE APPR. <i>W</i>		
DATE 11.04.07	DATE 11.04.11	DATE 11.04.12	DATE 11/04/12	DATE 11.04.12	DATE 11.04.12	

**PURPOSE:**

ADD AN INSPECTION WINDOW TO UNDERSIDE OF CROSSTUBE.

**CHANGE:**

NOTES 2 OF SHEET 1 IS AMENDED AS FOLLOWS:

**IS:**

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
 MASK UNDERSIDE OF CROSSTUBE AS SHOWN (HATCHED AREA) AND  
 PAINT OUTSIDE PER DART QSI 005 4.2  
 REMOVE MASKING AND APPLY CLEAR COAT

RELEASED  
2011-04-18UNDER REVIEW  
9/11/13  
BCAHL-G14  
11.07.28**WAS:**

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
 PAINT OUTSIDE PER DART QSI 005 4.2

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

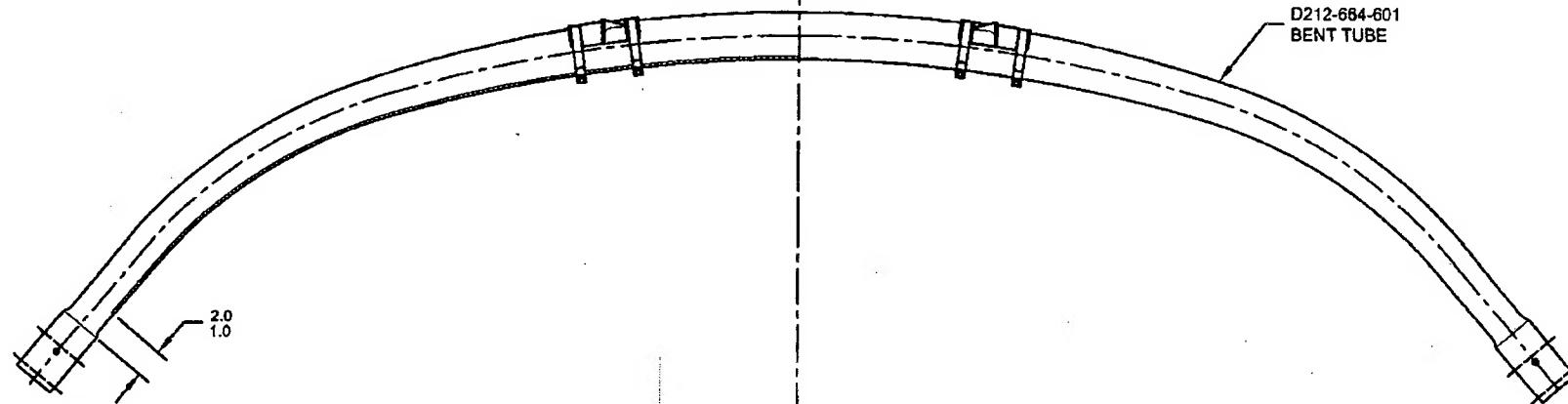
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

03094

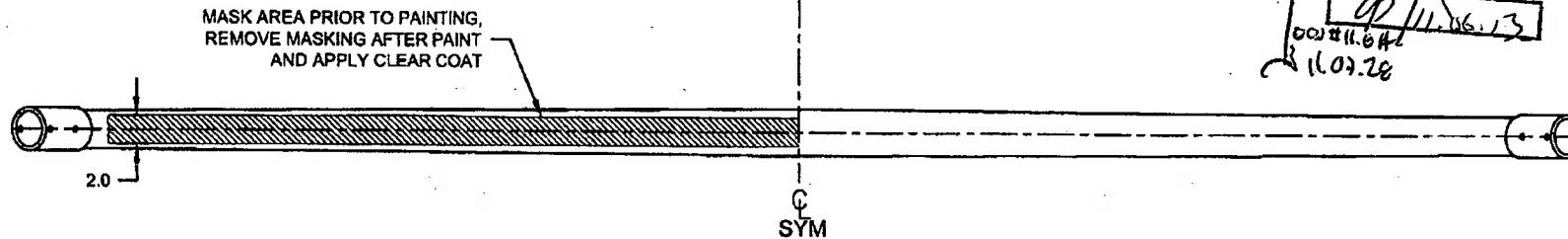
DRAWING NO. D212-664-241	TITLE CROSSTUBE ASSY (205/212 HI AFT)	REV. D	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D212-664-241-D-1	SHEET NO. SHEET 2 OF 2	SCALE NTS
DRAWN DATE 11.04.07	CHECKED DATE 11.04.11	OP	MFG. APPR. E	APPROVED MAD	DE APPR. <del>MM</del>	
			DATE 11.04.12	DATE 11/04/12	DATE 11.04.12	

IS:



WAS:

**D212-664-241/241B**  
**ASSEMBLY DETAIL**



**RELEASED**  
2011-04-18  
MM

**UNDER REVIEW**  
OP 11.06.13  
COO#11.04.28  
(10.28)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

83094

DRAWING NO. D212-664-241	TITLE CROSSTUBE ASS'Y (205/212 HI AFT)	REV. D	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D212-664-241-D-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>90</i>	CHECKED <i>ASS</i>	MFG. APPR. <i>DS</i>	APPROVED <i>MD</i>	DE APPR. <i>MM</i>		
DATE 11.07.15	DATE 11.07.20	DATE 11.07.21	DATE 11.07.21	DATE 11.07.21	DATE 11.07.21	

**PURPOSE:**

REPLACE MAGNOBOND WITH PROSEAL.

**CHANGE:****IS:**

Item	Qty -241	Qty -241B	Part Number	Description
7	A/R	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

**WAS:**

7	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
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NOTE 12 &amp; 15, SHEET 1 IS AMENDED AS FOLLOWS:

**IS:**

- 12) TO INSTALL D2940-1 SUPPORT: ABRADE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

**WAS:**

- 12) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED  
2011-07-28  
*MM*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries